

Work Order ID 76453

Tuesday, November 15, 2011 9:20:50 AM

76453

Page 1

Item ID: D3391-025

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 11/14/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 1.00

1

Customer:

Reference: REWORK TO REV I

Approvals: Process Plan: *Mf*Date: *11-11-15*

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3391	I
-------	---

300

300

Packaging

Memo

0.00

BR 11-11-17

Packaging

PULL FROM STOCK D3391-025 R73014

AND BRING TO FINISHING

310

310

Skidtubes

Memo

0.00

1 BR 11-11-17

Skidtubes

REMOVÉ WEARPLATES AND PUT BACK INTO STOCK :

REMOVE GASKETS AND SCRAP

D3537-I X 1
 D3537-7 X 1
 D3553-I X 1
 D3553-3 X 1

DISCARD HARDWARE AND PICK NEW

RE-ASSEMBLE WITH NEW WEARPLATES AND NEW HARDWARE

To Rev I



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Item ID: D3391-025**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Item Name:** Aft Tube Assembly**Stop*****NS2*****Start Date:** 11/14/2011 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 11/16/2011 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:** REWORK TO REV I**Approvals:** **Process Plan:** _____ **Date:** _____**Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____**SPC (Y/N):** _____ **Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description**

320

QC5- Inspect part completeness to step on W/O

320

QC

Quality Control

330

Identify as per dwg & Stock Location: _____

**Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

0.00

0.00

0.00

0.00

0.00

0.00

330

Packaging

Packaging

5/11/10

11/11/180

340

340

QC

Quality Control

5/11/10

11/11/180

11/11/180



Picklist Print

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Work Order ID: 76453
Parent Item: D3391-025
Parent Item Name: Aft Tube Assembly
Start Date: 11/14/2011 Required Date: 11/16/2011
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H 11.11.14 AS PER REV.I
DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS4-1032-130		Purchased	No				Each	2,000.0000		14			
---------------	--	-----------	----	--	--	--	------	------------	--	----	--	--	--

Insert

Location	Loc Qty	Loc Code
----------	---------	----------

ST280	1984	
-------	------	--

119084	1984	
--------	------	--

ST281	16	
-------	----	--

117717	2	
--------	---	--

118237	12	
--------	----	--

118312	2	
--------	---	--

ALS4-1032-225		Purchased	No				Each	2,181.0000		8			
---------------	--	-----------	----	--	--	--	------	------------	--	---	--	--	--

Insert

Location	Loc Qty	Loc Code
----------	---------	----------

ST281	2181	
-------	------	--

108696	285	
--------	-----	--

110768	62	
--------	----	--

118386	858	
--------	-----	--

118966	976	
--------	-----	--

Picklist Print

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Work Order ID: 76453

Parent Item: D3391-025

Start Date: 11/14/2011

Required Date: 11/16/2011

Parent Item Name: Aft Tube Assembly

Start Qty: 1.00

Required Qty: 1.00

AN3C4A
BOLT

Purchased No

Each 2,101.0000

6

BR 11-11-17

Location	Loc Qty	Loc Code
ST350	2101	
117313	2	
117688	5	
117872	22	
118112	16	
118451	2	
118700	92	
118838	962	
119328	1000	

AN3C5A
Bolt

Purchased No

Each 987.0000

4

BR 11-11-17

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	980	
116419	28	
117343	17	
117764	166	
117872	2	
118451	267	
119127	500	

AN960C10L
washer

NAS1149C0332R Purchased No

Each 0.0000

10

BR 11-11-17

118354.



Picklist Print

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Work Order ID: 76453

Parent Item: D3391-025

Start Date: 11/14/2011

Required Date: 11/16/2011

Parent Item Name: Aft Tube Assembly

Start Qty: 1.00

Required Qty: 1.00

D2646

Aft Cap

Manufactured

No

Each

243.0000

1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP002	226	
-------	-----	--

73294	26	
-------	----	--

73825	200	
-------	-----	--

FP004	5	
-------	---	--

68280	5	
-------	---	--

FP006	5	
-------	---	--

62678	5	
-------	---	--

FP-4	3	
------	---	--

70945	1	
-------	---	--

71070	2	
-------	---	--

fp5	4	
-----	---	--

71038	4	
-------	---	--

D3537-1

Wearpad

Manufactured

No

Each

80.0000

-1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP002	73	
-------	----	--

74436	56	
-------	----	--

74597	17	
-------	----	--

FP017	7	
-------	---	--

69817	5	
-------	---	--

70686	2	
-------	---	--

D3537-7

Wearpad

Manufactured

No

Each

19.0000

-1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	4	
----	---	--

71689	4	
-------	---	--

FP001	12	
-------	----	--

74617	12	
-------	----	--

FP017	3	
-------	---	--

71689	3	
-------	---	--



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Work Order ID: 76453

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/14/2011

Required Date: 11/16/2011

D3670-4-200

SPACER

Manufactured

No

Each

104.0000

4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	12	_____
71850	12	_____
LG001	92	_____
72851	92	_____

D3672-1

Phenolic Washer

Manufactured

No

Each

688.0000

2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP-A	424	_____
52505	0	_____
66821	424	_____
ST074	264	_____
72229	264	_____

D4095-047

Wearpad Assembly

Manufactured

No

76208.

Each

0.0000

0* b2 n-11-17.

D4095-049

Wearpad Assembly

Manufactured

No

76217.

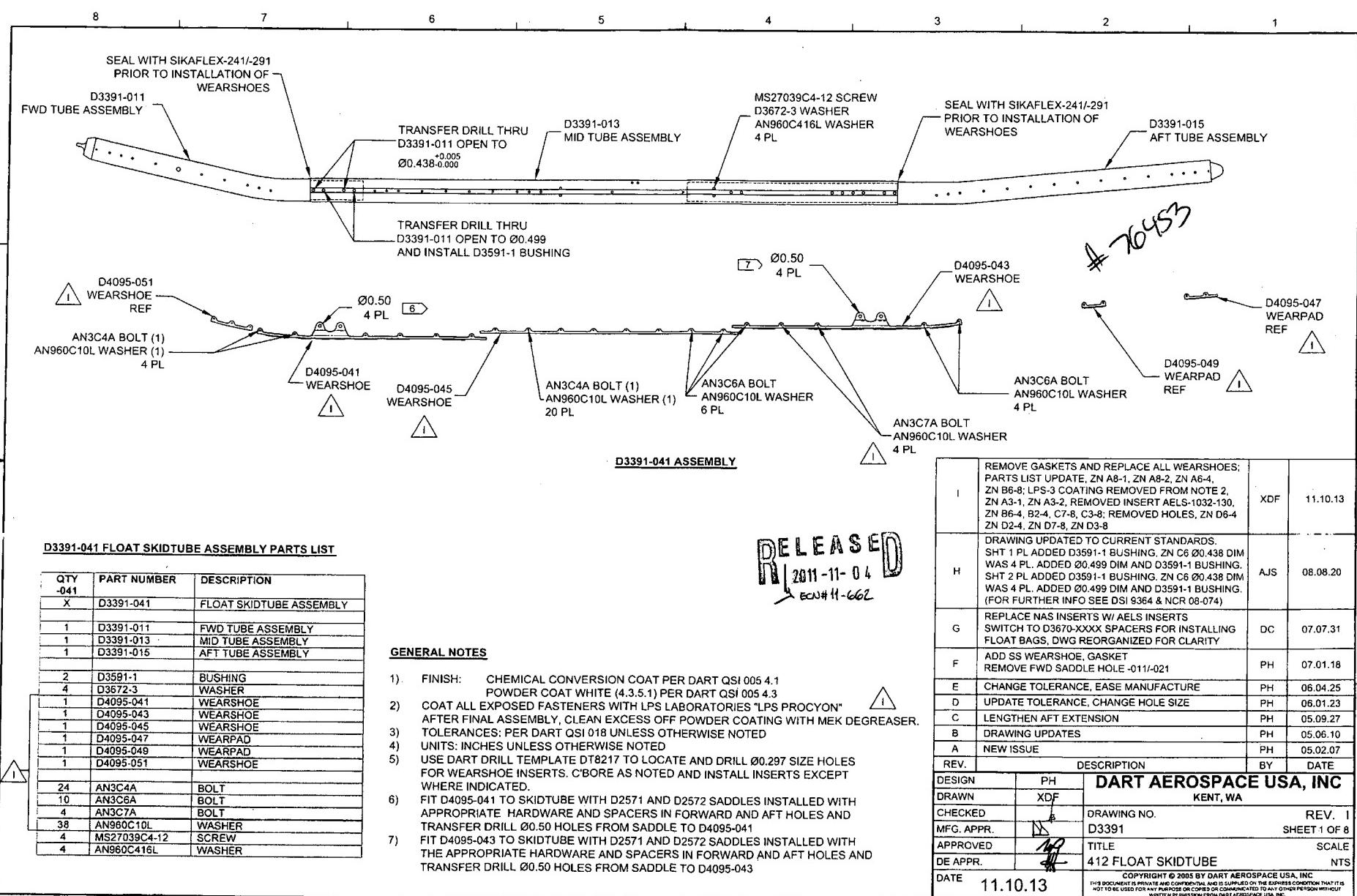
Each

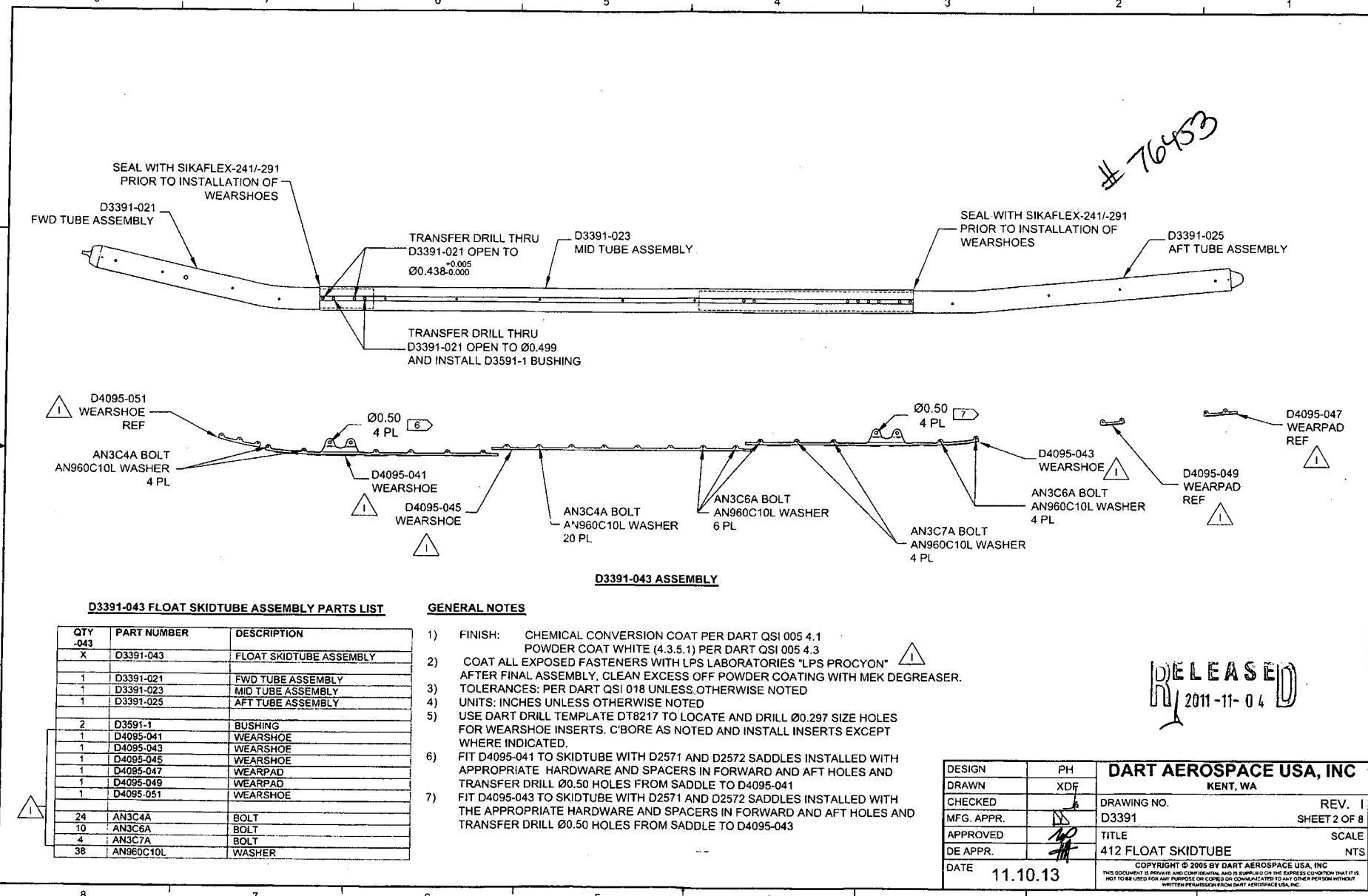
0.0000

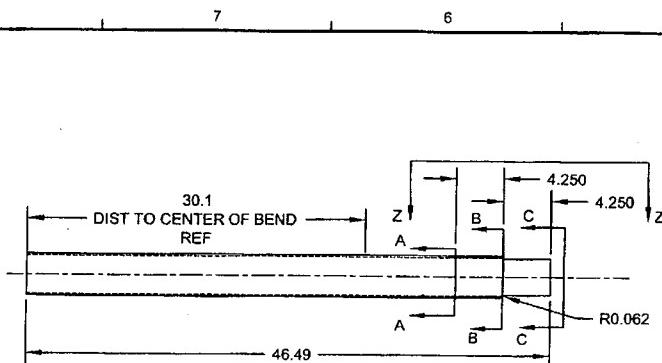
0 b2 11-11-17.

D3391-025

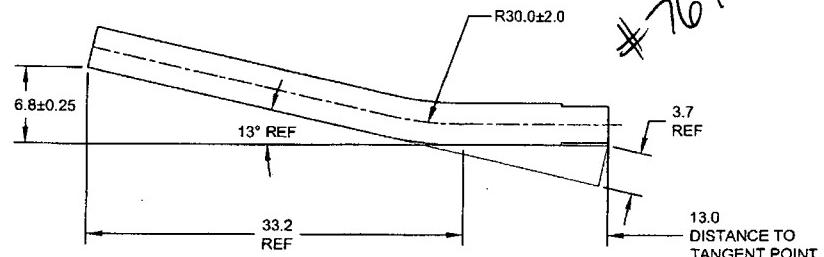
(14) 73014. B2 11-11-17.



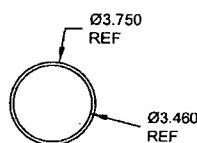




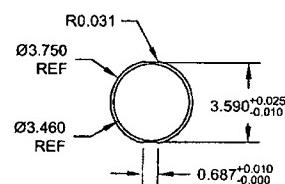
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



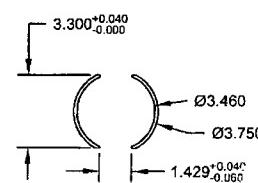
D3391-011-021 BENDING DETAIL
(MAKE FROM D3391-1)



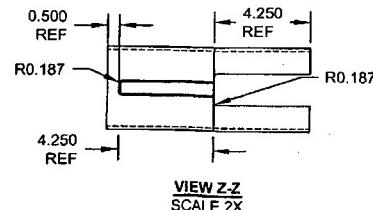
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	XDF	KENT, WA
CHECKED	NO	DRAWING NO.
MFG. APPR.	NO	REV. 1
APPROVED	NO	D3391
DE APPR.	NO	SHEET 3 OF 8
DATE	11.10.13	TITLE
		412 FLOAT SKIDTUBE
		NTS

RELEASED
2011-11-04

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